

Tuesday, 11/29/2005 7:13:30 PM  
Linda LacelleDate:  
User:

## Process Sheet

Customer Job Number	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH ASSEMBLY		
Estimate Number	: 25050		Part Number	: D2586		
P.O. Number	: 10303		Drawing Number	: D2586 REV C1		
This Issue	:		Project Number	: N/A		
Prsh't Rev.	: 11/29/2005 S.O. No. :		Drawing Revision	: C1		
First Issue	: NC		Material	:		
Previous Run	: / / Type : PURCHASED PARTS		Due Date	: 12/20/2005 Qty: 100 Um: Each		
Written By	: NO 02.01.31.			UN		
Checked & Approved By	:					
Comment	: Created By Auto Work Order <i>Reve</i> .					

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: *Re00000187* *10511130*

Possible Supplier: Southco, P/N: C2-32-25

Certification Required

## Tools:

2.0 C23225

DOOR LATCH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

DOOR LATCH

## Tools:

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- 1-Receive and inspect for transit damage
- 2-Attach certification
- 3-Stock Keys as: C2-32-25 Keys
- 4-Discard hardware

*10511130*

100

## Tools:

4.0 D30157

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Lock Nut

Pick:

Qty

Part Number

Description

Batch

1

D30157

Lock Nut

B24570

(97A)

B25208 (3x)

C 105112109

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/12/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:- Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH ASSEMBLY

Job Number: 25050

Part Number: D2586

Job Number:



Seq.#: Machine Or Operation:

Description :

Tools:

5.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Hole to 0.191"

FF 05/12/20

3

2-Counterface as per Dwg D2586

FF 05/12/13

97

3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

Tools:

6.0 QC5



INSPECT WORK TO CURRENT STEP



*205-12-20*

100

Comment: INSPECT WORK TO CURRENT STEP

Tools:

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 134

*Co 05/12/20*

100

Tools:

8.0 DC



DOCUMENT CONTROL



100

Comment: DOCUMENT CONTROL

Inspection Level 21

*Sub 05/12/21 100*

*(S) 05/12/21*

Tools:

Job Completion



W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval	Approval
						Chief Eng / Prod Mgr	QC Inspector

Part No:

PAR #:

Fault Category:

NCR: Yes

No

DQA:

Date:

QA: N/C Closed:

Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date &amp; initial all entries

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Dallas, TX 75220

1-800-465-6281  
[www.tchweb.com](http://www.tchweb.com)



## **CERTIFICATE OF COMPLIANCE**

Date: December 9, 2005

Customer Name: Dart Aerospace Ltd

Customer P.O. No.: PO00000187      TCH Order No.: 62399

Invoice No.: 76614      Date shipped: Dec 06, 2005

TCH Part No.: C2-32-25

Item Description: Black Lever Latch Raised Trigger

This is to certify that the items identified herein have been produced in accordance with applicable instructions and or specifications, drawings, approved samples and/or other descriptions set forth in the Purchase Order.

Signature:

Roberto Rivas  
Industrial CSR

Title:

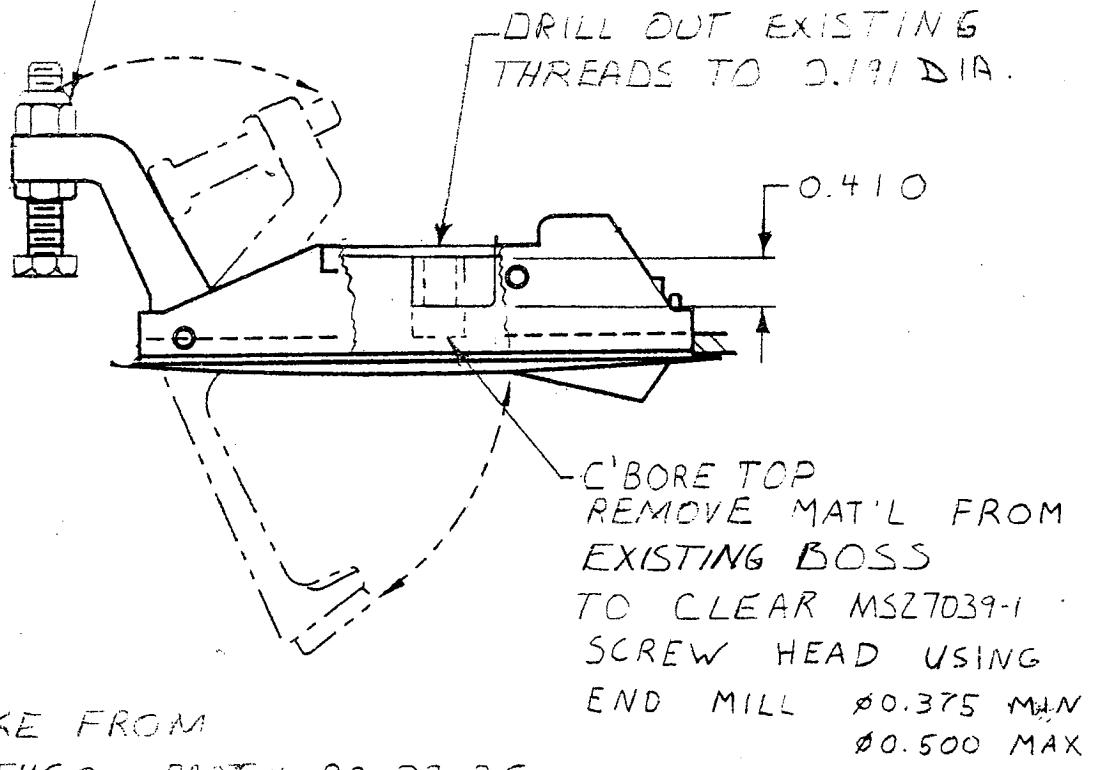


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2586	REV C SHEET 1 OF 1
DATE 97.09.03		TITLE DOOR LATCH	SCALE NTS
A	96.07.15	NEW ISSUE	
B	97.07.23	CHANGED C'BORE DEPTH	
C	97.09.03	REVISED C'BORE DEPTH	

RELEASED  
97/09/04 KE  
TSR A364

MS LOCK NUT

CONTROLLED COPY



NOTE: MAKE FROM  
SOUTHCO PART # C2-32-25